| | Monday, 7/9/2007 12:47:09 | I PM | • | | | | | |
|--------------------------|---------------------------|------------------|--------------------|------------------------------------|---|------------------|-----------------|------------|
| Date: User: | Kim Johnston | I F IVI | | Chaot | | | (3) | |
| • | | | <u>P</u> | rocess Sheet | | | | |
| Customer | | Dart Helicopters | Services | Drawing Name | : TUBE | | | |
| Job Number | : 33415 | | · · | | | | | |
| Estimate Nur | 1.5 | • | • | | D00000 | | | |
| P.O. Number | | 00 No . X | O A _ | Part Number | : D22823 : D2282 REV E | | | |
| This Issue Prsht Rev. | : 7/9/2007 : NC / | S.O. No. : 🏌 | 4/27 | Drawing Number | : N/A | | | |
| First Issue | ·NA | Type : M | ACHINED PARTS | Project Number Drawing Revision | : E, | | | |
| Previous Rur | 33259 | Type | DIOTAILE TELL | Material | ·NIA | | 100 | |
| Written By | • | 1 / | | Due Date | : 7/30/2007 | Qty: | <i>5</i> ∕0 Um: | Each |
| Checked & A | nnroved Bv : | Pthon | 00.09 | | | | | |
| Comment | • • | Rev:A Re | moved from 9 Digit | 05-12-02 JLM | | | | |
| | | | | * - · | | | | |
| Additional Pr | roduct | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| Job Number: | | | | | | | | |
| | | | | | | | | |
| Seq. #: | Machine Or C | Operation: | | Description : | | | | |
| 1.0 | | | 3(| 04 RD Tube .675 x .091W | | | | |
| 1.0 | | 91 | | 74 ND 1000 .010 X .00111 | III | | | |
| | | | | | | | | |
| | Comment: Qty.: 0.2 | | Total: 10.3898 | \$/a\ | 111 | intil north fort | | |
| ٠ | • | ` ' | | • • | II thicknoon | | | |
| | (M304TR0.6 | | nedule 40, Seamle | ess, Ø0.675" OD, 0.091" wa | II UUCKIICSS | | | |
| | | 105223 | Do lo | a la | | | | |
| 2.0 | HARDINGE | 0000 | RY TIVI | ÁRDINGE CNC LATHE SMALL | | | | |
| ۷.۰ | · HARDINGE | | <i>i</i> . | ANDINGE ONG EATTIE SHIREE | 1111111 | | | |
| | | | and the second | | | | | |
| | comment: HARDINGE | | NAALI | 3.00 | 11111111 | | | |
| _ | OMINON. HANDINGL | CINO EXTITE O | DIVIALL | grouph of | | | | |
| | 1.Turn as n | er Dwa D2282 | and Folio FA188 | | | | | |
| | 1-1um usp | or Day DZZOZ | and rollo 1 A 100 | / / | | | | |
| | 2-Deburr | | R | 207/09/19 | | | | |
| 3.0 | QC2 | | IN | SPECT PARTS AS THEY COME | OFF MACHINE | | | |
| 0.0 | | | | or Edit Militaria Met dome | | | | |
| | | | | | | | | |
| C | omment: INSPECT P | ADTO AO THE | V COME OFF MAC | THINE - FO | 7/2/20 | 1011 0101 1001 | | |
| 4.0 | QC8 | ARIO AO INE | | ECOND CHECK | 405/40 | | | |
| 4.0 | | | , 55 | ECOND CHECK | ا الاللاللالالالالالالالالالالالالالالا | | | |
| | | | | | | | | |
| | | | | | 7 // 11111111111 | | | |
| | omment: SECOND CI | HECK | | <u> </u> | 1 07.09 | 1.20. | | (∞) |
| 5.0 | PACKAGING 1 | | PA | ACKAGING RESOURCE #1 | | | _ | |
| | | | | | | | | |
| | | | | | | | | |
| С | omment: PACKAGING | | #1 | , , | | | | |
| | Identify and | Stock | //// | 1/1/2 | | | | |
| | Location: | | 616 | 71/19/20 | (100) | | | |
| | | | | | | | | |
| | | | // " | · · | | | | |
| | | | | | | | | |
| | | | | | | | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHA | ANGES | ·-···································· | | | ······································ |
|---------|------|------------------------|----------|--|------|-------------------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| Part No |): | PAR #: Fault Category: | NCR: Yes | No) DQ | A: 5 | Date: | 511912d |

QA: N/C Closed: ____ Date: ____

| NCR: | | W | ORK OR | DER NON-CONFORMANC | E (NCR) | | | |
|------|------|-------------------|----------------------|------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| | | Description of NC | | Corrective Action Section B | | Varification | A | Annaval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | ; | |
| | | | | | | | | |
| | | | | | , | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date:

Monday, 7/9/2007 12:47:09 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 33415

Part Number: D22823

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07109.20

Dart Aerospace Ltd

| W/O: | | WORK ORDER (| RK ORDER CHANGES | | | | | | | |
|---------|------|------------------------|------------------|--------|-----|-------------------------------|--------------------------|--|--|--|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | |
| | | | | | | : | | | | |
| | | | | | | | | | | |
| | | | | | | ; | | | | |
| | | | | | | | | | | |
| Part No | : | PAR #: Fault Category: | NCR: Yes | No DQA | \: | Date: | | | | |

QA: N/C Closed: ____ Date: ___

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--|-----------------------------|-----------|-----------------------|--------------------------|---------|
| | | Description of NC | | Corrective Action Section B | | Verification | | Ammound |
| DATE | STEP | Section A | | | Section C | Approval Chief Eng | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | : | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | : | |
| | | | | | | | | |

NOTE: Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 33415 |
|------------------------------|--------------|-------------|
| Description: Handle Tube | Part Number: | D2282-3 |
| Inspection Dwg: D2282 Rev: E | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

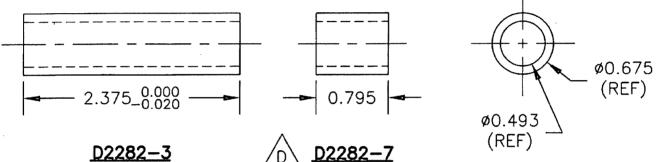
X First Article Prototype

| | _ | | | | | |
|----------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
| 2.375 | +0.000/-0.020 | 2.365 | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | · | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| - | | | | | | |
| | | | | | | |
| | | | | , | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| - | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | · | | | |
| | | | | | | |
| | | | | | | |

| Measured by: RP, | Audited by: | Prototype Approval: | N/A |
|------------------|----------------|---------------------|-----|
| Date: 67/09/19 | Date: 07/09/19 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| Α | 03.11.11 | New Issue P/O D350-615-041 | KJ/RF | |
| В | 05.04.19 | Tolerance changed | KJ/JLM | -1 |
| С | 06.03.15 | Dwg Rev update | KJ/JLM | |

| | DESIG | N BW | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
|----------|-------|---------|----------|---|
| DAVIT | CHEC | KED | APPROVED | DRAWING NO. REV. |
| | DATE | 4 | 1 aco | D2282 SHEET 1 OF 1 |
| | | 06.07 | | HANDLE TUBES 1: |
| 0 | Α | | 94.10.14 | NEW ISSUE |
| DELWASER | В | | 95.03.23 | RE-DESIGN |
| h TOO D | C | | 97.10.20 | CORRECTED NUMBERING SCHEME |
| 05/09/16 | D | | 05.03.16 | REDESIGN D2282-5; 0.795 WAS 0.750 |
| espen. | E | | 05.06.07 | D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030 |
| | | | <u> </u> | |



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED RO.063 x 0.063 DEEP 4 $0.090 \times 45^{\circ}$ 0.95 -CHAMFER 0.158 Ø0.700 R0.350 søØ?.9886 0.125 RETURN TO $0.080 \times 45^{\circ}$ ENGINEERING (REF) **CHAMFER** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER D2282-5

D2282-5 STEM:

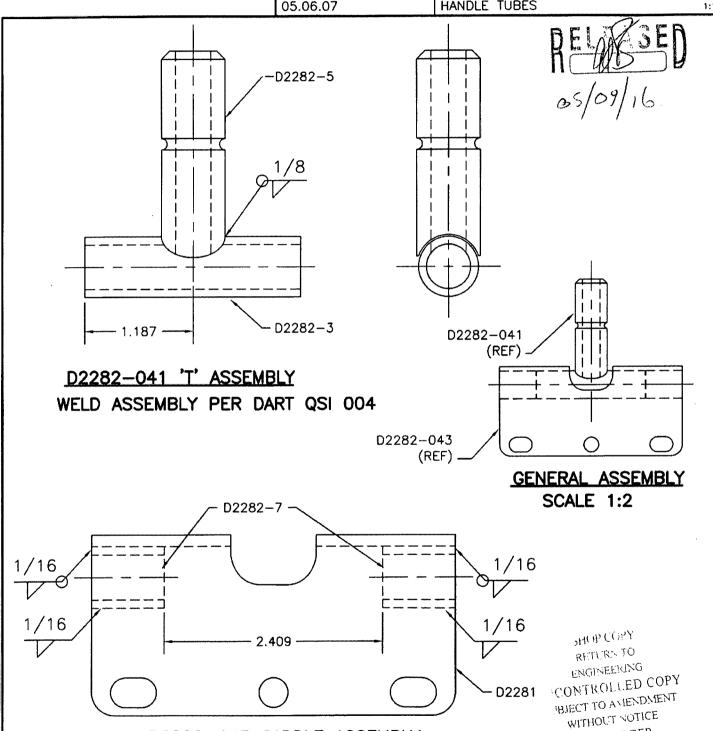
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright @ 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



| DESIGN BW | DRAWN BY | DART AEROS HAWKESBURY, ONT | |
|--------------|----------|-------------------------------|--------------|
| CHECKED | APPROVED | DRAWING NO. | REV. E |
| u' | 1 1116 | D2282 | SHEET 2 OF 2 |
| DATE | 1 400 | TITLE | SCALE |
| 05.06.07 | | HANDLE TUBES | 1:1 |



Copyright 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004